

Date: Monday, 25/05/2009 1:30:44 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)	
Job Number :	48176			
Estimate Number :	13260			
P.O. Number :		Part Number :	D350766011	
This Issue :	25/05/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	IIN350-766 REV A	
First Issue :	11	Project Number :		
Previous Run :	47252	Drawing Revision :	A	
		Material :		
Written By :		Due Date :	05/06/2009	Qty: 3 Um: Each
Checked & Approved By :	<u>JUD 09.05.25</u>			
Comment :	Est REV A NEW ISSUE 08/04/08 DL verified by:DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Sorbalos



(PK)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 ~~CHG001~~

chg 002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D36551	PANEL
-----	--------	-------

Rev 6



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PANEL

batch:

B470A

9/4/2

SP

4.0	D36553	PANEL
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

PANEL

batch:

48257

9/4/2

SP

5.0	MS21059L3	Nut Plate
-----	-----------	-----------



(3X)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut Plate

batch:

M109662

9/6/2

SP

Dart Aerospace Ltd

W/O: 48176		EST: 13260						WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector				
05.06.03	1.0	update to chg 002. Perm. Change Per ECW 08-543	E	09.06.04		05.06.03	05.06.03				

Part No: D350-766-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 1:30:44 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)

Job Number: 48176

Part Number: D350766011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	CCR274SS34	Cherry Rivet
-----	------------	--------------



Comment: Qty.: 8.0000 (s)/Unit Total: 24.0000 (s)
Cherry Rivet
batch: M107438

9/6/2

50

7.0	AN5261032R12	Screw
-----	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
Screw
batch: M1568

9/6/2

50

8.0	AN5261032R20	Screw
-----	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
Screw
batch: M10216

9/6/2

50

9.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

509/06/03 (43)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-766-011
Location: _____
PPP Rev: B

9/6/4

54

11.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/06/04

Job Completion



mf
09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

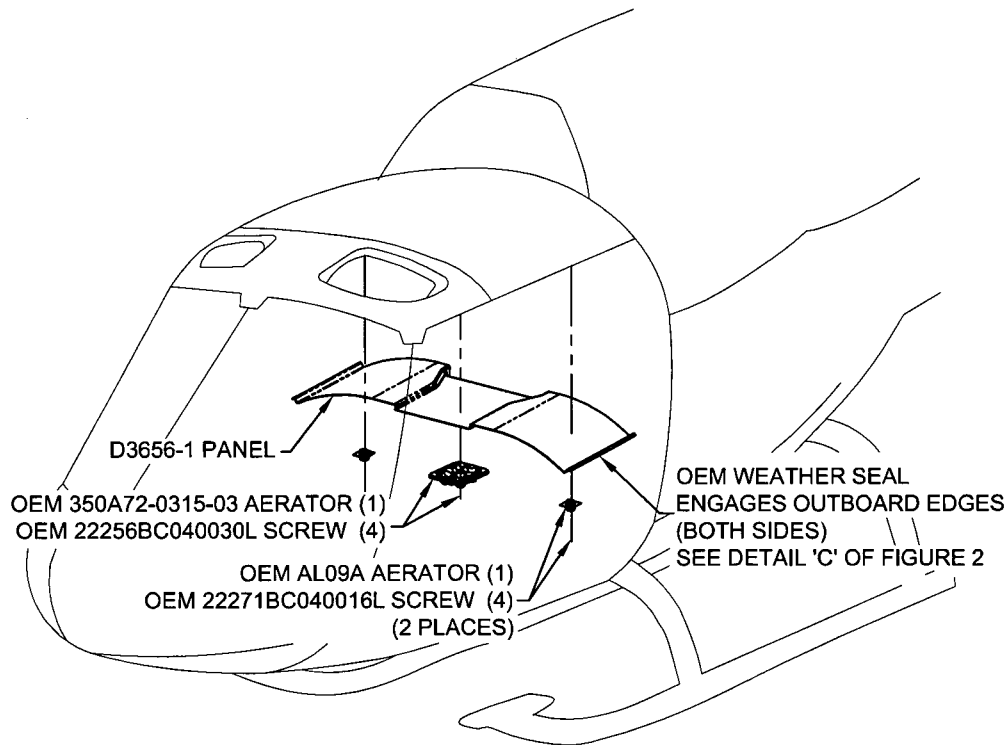


Figure 4 – Installation of D3656-1 Panel

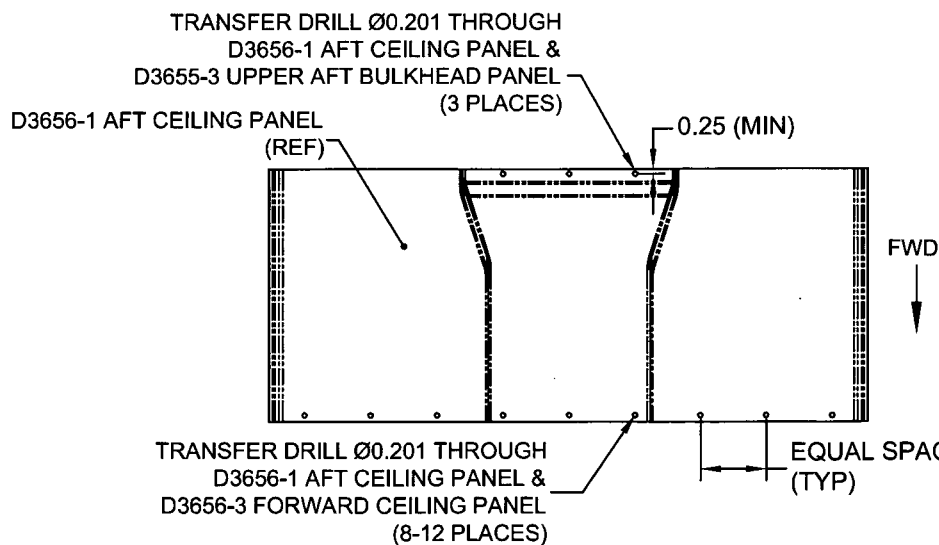


Figure 5 – Transfer Drill Locations
(Looking up at D3656-1 Aft Ceiling Panel)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48170

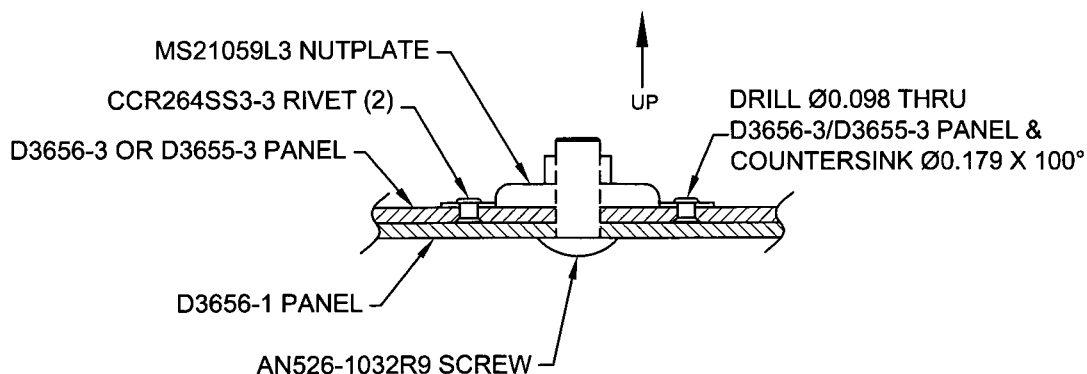


Figure 6 – Nutplate Installation

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X	D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
1		D3655-1	PANEL
1		D3655-3	PANEL
	1	D3656-1	PANEL
	1	D3656-3	PANEL
4	15	MS21059L3	NUTPLATE
	30	CCR264SS3-3	RIVET
8		CCR274SS3-4	RIVET
	15	AN526-1032R9	SCREW
2		AN526-1032R12	SCREW
2		AN526-1032R20	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48176

Monday, 25/05/2009 1:30:44 PM
Julie Dawson

Process Sheet

23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
Job Number : 48176
Estimate Number : 13260
P.O. Number :
Th : Issue : 25/05/2009 S.O. No. :
Part Rev. : NC Part Number : D350766011
First Issue : // Type : THERMOFORMING Drawing Number : IIN350-766 REV A
Previous Run : 47252 Project Number :
Drawing Revision : A
Material :
Due Date : 05/06/2009 Qty: 3 Um: Each
Written By :
Checked & Approved By : JUD 09.05.25
Comment : Est REV A NEW ISSUE 08/04/08 DL verified by:DD

REFERENCE ONLY

Additional Product

Doc Number:



Seq. #: Machine Or Operation: Description :
1.0 DC DOCUMENT CONTROL



JUD 09.05.02



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-011 CHG001

ECN 08.543

2.0 PACKAGING 1 PACKAGING RESOURCE #1



CHG 002
SkyLight port cut D3655 Rev.
D3656 B.



Comment: PACKAGING RESOURCE #1

Pick Packing Kit cut out CHG 001

3.0 D36551 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PANEL

batch: B470A

9/4/2

SP

4.0 D36553 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PANEL

batch:

5.0 MS21059L3 Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut Plate

batch: M109662

9/6/2

SP

(3X)

Date: Tuesday, 02/06/2009 12:50:24 PM

User: Julie Dawson

JOB HISTORY : DETAIL

Job Number	: 48176	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 13260	DWG Name	: INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
Purchase Order #	:	Part Number	: D350766011
Complete Date	: / / : : AM	DWG Number	: IIN350-766 REV A
Rev.	: A		

DUE DATE	ORDERED	DELIVERED
05/06/2009	3	0

3.0 D36551-PANEL	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2009	QUIR01: Quirion, Sonia	D36551	3.000	\$187.64	Lot # 47019 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$187.64	

5.0 MS21059L3-Nut Plate	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2009	QUIR01: Quirion, Sonia	MS21059L3	12.000	\$8.75	Lot # 109962 Qty. 12
Subtotal:	QTD:	0 CTD:	12	\$8.75	

6.0 CCR274SS34-Cherry Rivet	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2009	QUIR01: Quirion, Sonia	CCR274SS34	24.000	\$10.40	Lot # 107438 Qty. 24
Subtotal:	QTD:	0 CTD:	24	\$10.40	

7.0 AN5261032R12-Screw	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2009	QUIR01: Quirion, Sonia	AN5261032R12	6.000	\$0.48	Lot # 1568 Qty. 6
Subtotal:	QTD:	0 CTD:	6	\$0.48	

8.0 AN5261032R20-Screw	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2009	QUIR01: Quirion, Sonia	AN5261032R20	6.000	\$1.00	Lot # 10216 Qty. 6
Subtotal:	QTD:	0 CTD:	6	\$1.00	

		TIME	COST	
	Machine Time:	0.00	\$0.00	
	Labor:	0.00	\$0.00	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$208.27	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$208.27	

COST PER UNIT:	\$208.27
-----------------------	----------